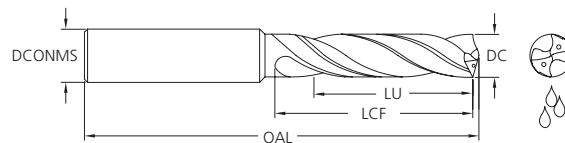


CYCLONE CDA 5xD - Series CDACR



Features:

- 2 Flutes.
- Lower Thrust Point Geometry.
- Enhanced Double Margin Design.
- Coolant Fed.
- Usable length (LU) = LCF - (1.5 x DC).

Benefits:

- Reduced cutting forces allowing for heavier feed rates.
- Improved performance in Non-Ferrous materials.
- Back margin location allows for quicker engagement in hole.
- Improved hole finishes.
- Improved location when drilling through cross holes.
- Higher heat resistance means higher speed and feed capabilities.

CDA vs. CXD Style HP Drills:

The CDA provides a deeper flute depth than the CXD style drill for increased chip evacuation. Also, The CDA's point relief and edge protection is maximized for machining in non-ferrous materials.

ALtima® Plus		DC (m7)				DCONMS (h6)	OAL		LCF	
Tool No.	EDP	Inch	Letter/Wire	mm	Decimal	mm	Inch	mm	Inch	mm
CDACRM0300	07300			3.00	.1181	6		66		28
CDACR1200	07301		#31		.1200	6	2.60		1.102	
CDACRM0310	07302			3.10	.1220	6		66		28
CDACR1250	07303	1/8			.1250	6	2.60		1.102	
CDACRM0320	07304			3.20	.1260	6		66		28
CDACR1285	07305		#30		.1285	6	2.60		1.102	
CDACRM0330	07306			3.30	.1299	6		66		28
CDACRM0340	07307			3.40	.1339	6		66		28
CDACR1360	07308		#29		.1360	6	2.60		1.102	
CDACRM0350	07309			3.50	.1378	6		66		28
CDACR1406	07310	9/64			.1406	6	2.60		1.102	
CDACRM0360	07311			3.60	.1417	6		66		28
CDACR1440	07312		#27		.1440	6	2.60		1.102	
CDACRM0370	07313			3.70	.1457	6		66		28
CDACR1470	07314		#26		.1470	6	2.60		1.102	
CDACR1495	07315		#25		.1495	6	2.91		1.417	
CDACRM0380	07316			3.80	.1496	6		74		36
CDACR1520	07317		#24		.1520	6	2.91		1.417	
CDACRM0390	07318			3.90	.1535	6		74		36
CDACR1562	07319	5/32			.1562	6	2.91		1.417	

Inch	
DC	Tolerance (m7)
.0000 - .1181	+0.0008/+0.0047
.1182 - .2362	+0.0016/+0.0063
.2363 - .3937	+0.0024/+0.0083
.3938 - .5000	+0.0027/+0.0098

Inch	
DCONMS	Tolerance (h6)
.0000 - .1181	+0/-0.00024
.1182 - .2362	+0/-0.00031
.2363 - .3937	+0/-0.00035
.3938 - .5000	+0/-0.00043

Metric (mm)	
DC	Tolerance (m7)
0 - 3.0	+0.002/+0.012
3.01 - 6.0	+0.004/+0.016
6.01 - 10.0	+0.006/+0.021
10.01 - 12.7	+0.007/+0.025

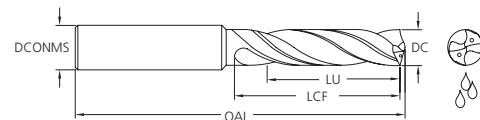
Metric (mm)	
DCONMS	Tolerance (h6)
0 - 3.0	+0/-0.006
3.01 - 6.0	+0/-0.008
6.01 - 10.0	+0/-0.009
10.01 - 12.7	+0/-0.011



ALtima® Plus		DC (m7)				DCONMS (h6)	OAL		LCF	
Tool No.	EDP	Inch	Letter/Wire	mm	Decimal	mm	Inch	mm	Inch	mm
CDACRM0400	07320			4.00	.1575	6		74		36
CDACR1590	07321		#21		.1590	6	2.91		1.417	
CDACR1610	07322		#20		.1610	6	2.91		1.417	
CDACRM0410	07323			4.10	.1614	6		74		36
CDACRM0420	07324			4.20	.1654	6		74		36
CDACR1660	07325		#19		.1660	6	2.91		1.417	
CDACRM0430	07326			4.30	.1693	6		74		36
CDACR1719	07327	11/64			.1719	6	2.91		1.417	
CDACR1730	07328		#17		.1730	6	2.91		1.417	
CDACRM0440	07329			4.40	.1732	6		74		36
CDACR1770	07330		#16		.1770	6	2.91		1.417	
CDACRM0450	07331			4.50	.1772	6		74		36
CDACRM0460	07332			4.60	.1811	6		74		36
CDACRM0470	07333			4.70	.1850	6		74		36
CDACR1875	07334	3/16			.1875	6	3.23		1.732	
CDACRM0480	07335			4.80	.1890	6		82		44
CDACR1910	07337		#11		.1910	6	3.23		1.732	
CDACRM0490	07338			4.90	.1929	6		82		44
CDACR1935	07339		#10		.1935	6	3.23		1.732	
CDACRM0500	07340			5.00	.1968	6		82		44
CDACRM0510	07341			5.10	.2008	6		82		44
CDACR2031	07342	13/64			.2031	6	3.23		1.732	
CDACRM0520	07343			5.20	.2047	6		82		44
CDACRM0530	07344			5.30	.2087	6		82		44
CDACRM0540	07345			5.40	.2126	6		82		44
CDACRM0550	07346			5.50	.2165	6		82		44
CDACR2187	07347	7/32			.2187	6	3.23		1.732	
CDACRM0560	07348			5.60	.2205	6		82		44
CDACRM0570	07349			5.70	.2244	6		82		44
CDACRM0580	07350			5.80	.2283	6		82		44
CDACRM0590	07351			5.90	.2323	6		82		44
CDACR2340	07352		A		.2340	6	3.23		1.732	
CDACRM0600	07353			6.00	.2362	6		82		44
CDACRM0610	07354			6.10	.2402	8		91		53
CDACRM0620	07355			6.20	.2441	8		91		53
CDACRM0630	07356			6.30	.2480	8		91		53
CDACR2500	07357	1/4			.2500	8	3.58		2.087	
CDACRM0640	07358			6.40	.2520	8		91		53
CDACRM0650	07359			6.50	.2559	8		91		53
CDACR2570	07360		F		.2570	8	3.58		2.087	
CDACRM0660	07406			6.60	.2598	8		91		53
CDACRM0670	07361			6.70	.2638	8		91		53
CDACR2656	07362	17/64			.2656	8	3.58		2.087	



CYCLONE CDA 5xD - Series CDACR *Continued*



ALtima® Plus		DC (m7)				DCONMS (h6)	OAL		LCF	
Tool No.	EDP	Inch	Letter/Wire	mm	Decimal	mm	Inch	mm	Inch	mm
CDACRM0680	07363			6.80	.2677	8		91		53
CDACRM0690	07364			6.90	.2717	8		91		53
CDACR2720	07365		I		.2720	8	3.58		2.087	
CDACRM0700	07366			7.00	.2756	8		91		53
CDACRM0710	07407			7.10	.2795	8		91		53
CDACR2812	07367	9/32			.2812	8	3.58		2.087	
CDACRM0720	07368			7.20	.2835	8		91		53
CDACRM0730	07369			7.30	.2874	8		91		53
CDACRM0740	07370			7.40	.2913	8		91		53
CDACRM0750	07371			7.50	.2953	8		91		53
CDACR2969	07372	19/64			.2969	8	3.58		2.087	
CDACRM0760	07408			7.60	.2992	8		91		53
CDACRM0770	07409			7.70	.3031	8		91		53
CDACRM0780	07373			7.80	.3071	8		91		53
CDACRM0790	07410			7.90	.3110	8		91		53
CDACR3125	07374	5/16			.3125	8	3.58		2.087	
CDACRM0800	07375			8.00	.3150	8		91		53
CDACRM0810	07376			8.10	.3189	10		103		61
CDACRM0820	07405			8.20	.3228	10		103		61
CDACRM0830	07411			8.30	.3268	10		103		61
CDACR3281	07377	21/64			.3281	10	4.06		2.402	
CDACRM0840	07378			8.40	.3307	10		103		61
CDACR3320	07379		Q		.3320	10	4.06		2.402	
CDACRM0850	07380			8.50	.3346	10		103		61
CDACRM0860	07412			8.60	.3386	10		103		61
CDACRM0870	07413			8.70	.3425	10		103		61
CDACR3438	07381	11/32			.3438	10	4.06		2.402	
CDACRM0880	07414			8.80	.3465	10		103		61
CDACRM0890	07415			8.90	.3504	10		103		61
CDACRM0900	07382			9.00	.3543	10		103		61
CDACRM0910	07416			9.10	.3583	10		103		61
CDACR3594	07383	23/64			.3594	10	4.06		2.402	
CDACRM0920	07417			9.20	.3622	10		103		61
CDACRM0930	07418			9.30	.3661	10		103		61
CDACR3680	07384		U		.3680	10	4.06		2.402	



Altima® Plus		DC (m7)				DCONMS (h6)	OAL		LCF	
Tool No.	EDP	Inch	Letter/Wire	mm	Decimal	mm	Inch	mm	Inch	mm
CDACRM0940	07419			9.40	.3701	10		103		61
CDACRM0950	07385			9.50	.3740	10		103		61
CDACR3750	07386	3/8			.3750	10	4.06		2.402	
CDACRM0960	07420			9.60	.3780	10		103		61
CDACRM0970	07387			9.70	.3819	10		103		61
CDACRM0980	07421			9.80	.3858	10		103		61
CDACRM0990	07422			9.90	.3898	10		103		61
CDACR3906	07388	25/64			.3906	10	4.06		2.402	
CDACRM1000	07389			10.00	.3937	10		103		61
CDACRM1010	07423			10.10	.3976	12		118		71
CDACRM1020	07390			10.20	.4016	12		118		71
CDACRM1030	07424			10.30	.4055	12		118		71
CDACR4062	07391	13/32			.4062	12	4.65		2.795	
CDACRM1040	07392			10.40	.4094	12		118		71
CDACRM1050	07393			10.50	.4134	12		118		71
CDACRM1060	07394			10.60	.4173	12		118		71
CDACRM1070	07425			10.70	.4213	12		118		71
CDACR4219	07395	27/64			.4219	12	4.65		2.795	
CDACRM1080	07426			10.80	.4252	12		118		71
CDACRM1090	07427			10.90	.4291	12		118		71
CDACRM1100	07396			11.00	.4331	12		118		71
CDACRM1110	07428			11.10	.4370	12		118		71
CDACR4375	07397	7/16			.4375	12	4.65		2.795	
CDACRM1120	07429			11.20	.4409	12		118		71
CDACRM1130	07430			11.30	.4449	12		118		71
CDACRM1140	07431			11.40	.4488	12		118		71
CDACRM1150	07398			11.50	.4528	12		118		71
CDACR4531	07399	29/64			.4531	12	4.65		2.795	
CDACRM1160	07432			11.60	.4567	12		118		71
CDACRM1170	07433			11.70	.4606	12		118		71
CDACRM1180	07434			11.80	.4646	12		118		71
CDACRM1190	07435			11.90	.4685	12		118		71
CDACR4688	07400	15/32			.4688	12	4.65		2.795	
CDACRM1200	07401			12.00	.4724	12		118		71
CDACR4844	07402	31/64			.4844	14	4.88		3.031	
CDACRM1250	07403			12.50	.4921	14		124		77
CDACR5000	07404	1/2			.5000	14	4.88		3.031	

